



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2654-5

Job Sheet 202834



Part No: D2654-5

Job Qty: 6 pcs

Part Name: Web



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/4/19

Job Tracking No:

Due Date: 11/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV F SHEET 2 IPP Rev:D 99.02.04 Fixed typo, Changed procedure DM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	6 pcs	11/29/19		0.00	3.37	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	6 pcs	11/29/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
120	Handfinish - 1-1 Chemical-B4B	6 pcs	11/29/19		0.00	1.43	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		
							Handfinish - 1 - 4 - B4B		
							Handfinish - 1 - 5 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S231220



Part: D2654-5

Job No: 202834

Serial No/Batch: S231220

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 11/13/19

Plex 11/4/19 1:19 PM Dart.lajeunesse.marie

				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
130	QC 7	6	11/29/19	0.00 0.00	QC 7 - 10
		pcs			QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
					QC 7 - 61
					QC 7 - 81
					QC 7 - 76

Marie

				QC 7 - 79	
140 Packaging 3-1 - Stock - B4B	6 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
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				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	TF
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150 QC 21 - SA	6 pcs	11/29/19	0.00 0.00	QC 21 - SA - 21	bas
				QC 21 - SA - 70	21
				QC 21 - SA - 53	bas

NOV 18 2019

Part Op 100 - (Skid tubes) 1-Cut D2600-7 to length as per Dwg D2654 2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg Descriptions: D2654

110 - (QC5- Inspect part completeness to step on W/O)

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7-Inspect Chemical Conversion Coat)

140 - (Identify as per dwg & Stock Location: LG002) LOCATION : LG002

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-7-140	Extrusion I-Beam Thick	6 pcs (1 ea)	100-Skid tubes - 1	B162496

Job Allocations

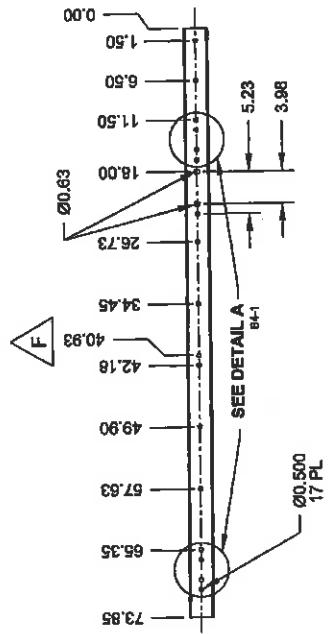
Operation	Component Part	Required	Inventory	Allocated
100-Skid tubes - 1	D2600-7-140	6	107	0

Part Specifications

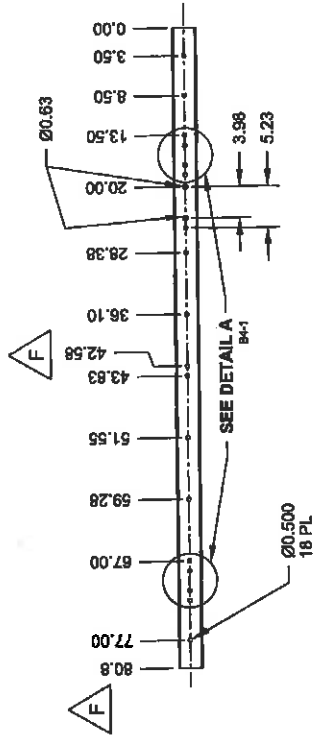
Specifications could not be found.

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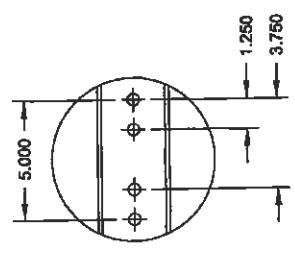
1 2 3 4 5 6 7 8



D2654-1 WEB



D2654-3 WEB



DETAIL A

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SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 207874
11-5
1911-04

RELEASED
R 2011-08-12
UN

- NOTES:
- 1) MAKE D2654-1/3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/7 FROM D2600-7-125 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH PIN "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
 - 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

REV.	DESCRIPTION	CP	SC	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5-7, 80.8 WAS 80.5, INCORPORATED DED D2654-E-2				11.05.05
E	CHANGE LENGTHS, REFORMAT				04.05.28
D	CHW HOLES CHANGED TO 80.63				98.01.15
C	CHANGED HOLE PATTERN				97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438				97.05.28
A	NEW ISSUE				97.03.25
DESIGN					
DRAWN					
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE	11.05.05				

DART AEROSPACE USA, INC
PORT HADLOCK, WA
DRAWING NO. D2654
SHEET 1 OF 2
SCALE
NTS
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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QSI042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____